



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3012
Job Sheet 179149



Part No: 646.3012

Job Qty: 20 ea

Part Name: Lower Guide



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 7/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C SHEETS 1,3,5,8,9 IPP REV:A NEW ISSUE 13/01/30 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea			0.00	0.00	Start Up Machining-1		
100	Bandsaw	20 pcs			0.00	1.44	Bandsaw1		
110	CNC Vertical Machining	20 pcs			0.20	22.99	HAAS1-1		
120	QC	20 pcs			0.00	0.00	QC2 Machining-1		
130	QC	20 pcs			0.00	0.00	QC8 Machining-1		
140	Outsource	20 pcs					ATG001-VC	5	
150	Packaging	20 pcs			0.00	0.00	Packaging2		
155	QC	20 pcs			0.00	0.00	QC6		
180	Packaging	20 pcs			0.00	0.00	Packaging3-1		
190	QC21-SA	20 Ea			0.00	0.00	QC21		

Part Op 100 - Cut Blank at 27.500" ***ONE BLANK MAKE TWO PARTS***

Descriptions: 110 - 1-Machine per folio FB159

140 - Issue P/O to ATG 20040831 Hard Anodize, Color Black and Prime as per Dwg 646.3000

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S0.375X8.000	7075-T6S Sheet .375" Thick Plate X 8" Wide	22.9200 ft (1.146 ea)	90-Start up Operation	
5090187x2				
507001983	5017378x5			

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S0.375X8.000	23	18	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Guide	0.125inches $\pm$ 0.005	0.130 0.120		
2	Lower Guide	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	
3	Lower Guide	0.375inches $\pm$ 0.005	0.380 0.370		
4	Lower Guide	0.250inches $\pm$ 0.005	0.255 0.245	Radius	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

5	Lower Guide	0.209inches + 0.005 - 0.001	0.214 0.208	Diameter
6	Lower Guide	0.177inches + 0.005 - 0.001	0.182 0.176	Diameter
7	Lower Guide	0.250inches ± 0.005	0.255 0.245	

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DART
AEROSPACE

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S106404



Part: 646.3012

Job No: 179149

Serial No/Batch: S106404

Revision:

Inspector:

Exp Date:

Instructions:

Date: 08/29/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 16.6%;">Skid-tube ☐</td> <td style="width: 16.6%;">Cross tube ☐</td> <td style="width: 16.6%;">Water Jet ☐</td> <td style="width: 16.6%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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OTHER : ☐																									

17/2/19

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <i>M. M.</i>		Audited by:		Preliminary Approval:	
Date: <i>20/6/08/28</i>		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	14.06.25	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040871**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO040871
PO Date: 8/28/18
Due Date: 9/18/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Attention: Lalande, Marc-Andre

Via: Ground
Pymt Terms: Net 30

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171196	647.3912	Breakaway Tip Wirestrike for Wire Strike Issue P/O to ATG : 1- Black Anodize as per Dwg 647.3900 2- PRIME AS PER DWG, SEE NOTE #9 Certification of Conformity is required	Firmed	-	9/7/18	16 pcs	0 pcs	16 pcs	\$12.85/pcs	\$205.60
2	178442	RB23007615-21	Guide -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	9/18/18	7 pcs	0 pcs	7 pcs	\$9.75/pcs	\$68.25

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	181077	D5237-1	Bracket : Various STC's Issue P/O to ATG: ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2 Certification of Conformity is required Issue P/O to ATG: ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2 Certification of Conformity is required	Firmed	-	9/18/18	8 pcs	0 pcs	8 pcs	\$9.75/pcs	\$78.00
4	181417	647.7911	Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N as per Dwg 647.7900 Certification of Conformity is required	Firmed	-	9/18/18	57 pcs	0 pcs	57 pcs	\$8.30/pcs	\$473.10
5	179149	646.3012	Lower Guide Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3000	Firmed	-	9/18/18	20 pcs	0 pcs	20 pcs	\$21.30/pcs	\$426.00
Grand Total:										\$1,250.95	

Order Notes

Order Notes**Procurement Quality Clauses**

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/4/18 2:32 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915983

Date: 11-Sep-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
45 ea	Part: 647.7911 ✓ Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23670 PO: PO040871 Line: 4	Rev: N/C	
20 ea	Part: 646.3012 ✓ Lower Guide Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23671 PO: PO040871 Line: 5	Rev: NC	DAS 61 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>11/9/18</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			